

Work Order ID 52892

October 19, 2009 10:37:37 AM

Page 1

Item ID: D3172-041
Revision ID: C
Item Name: Basket Base Assembly

Accept

Setup Start

Stop

Start Date: 10/19/09 Start Qty: 1.00

Required Date: 10/27/09 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: *RP*

Date: *09-10-19*

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3172

Rev C

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut Qty 4 D3166-1 as per Dwg D3172-1 2-Cut 3/4" x 3/4" square tubing as per Dwg D3172-3 Drill holes in D3172-3 as per Dwg D3172-4-Deburr & Remove all markings from material 5-Weld as per Dwg D3172 using Welding Table and corner Jig & D3172-1 Deburr as r

PD 09.11.02

110

QC9- Inspect visual per QS1004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

Cpl 09.11.03

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

⇒ S 09/16/04

(f) f

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Accept

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Stop

Start Date: 10/19/09 Start Qty: 1.00
Required Date: 10/27/09 Req'd Qty: 1.00

Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M112140</i> Memo 1ST COAT: <i>7:45am</i> START TIME: <i>7:45am</i> OVEN TEMPERATURE: <i>320°F</i> FINISH TIME: <i>8:15am</i> ***** 2nd coat if necessary***** 2ND COAT: <i>8:30am</i> START TIME: <i>8:30am</i> OVEN TEMPERATURE: <i>400°F</i> FINISH TIME: <i>9:00am</i>	0.00 0.00	<i>7</i>	<i>09/11/05</i>		<i>(X)</i>	<i>0</i>		
140 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	<i>WMD</i>	<i>09/11/05</i>		<i>X1</i>			

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Accept

Revision ID: C

Item Name: Basket Base Assembly

Start Date: 10/19/09 Start Qty: 1.00

Required Date: 10/27/09 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

J 289 L / 09/11/09

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/10
MF 09-11-10

Picklist Print

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Work Order ID: 52892

Parent Item: D3172-041RevC

Parent Item Name: Basket Base Assembly

Start Date: 10/19/09

Required Date: 10/27/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2012-117RevC		Manufactured	No			100	Each	28.0000	2.0000			



Clevis

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

28

31101

2

52498

26

D2232-3RevC

Manufactured

No

100

Each

9.0000

2.0000



Basket Hinge

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

8

50024

2

51870

6

Main Warehouse

WA

1

50986

1

PD 09.10.28

PD 09.11.02

Picklist Print

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Work Order ID: 52892

Parent Item: D3172-041RevC

Parent Item Name: Basket Base Assembly


Start Date: 10/19/09

Required Date: 10/27/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2327-3RevD		Manufactured	No			100	Each	46.0000	2.0000			
												
Spacer Bushing												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 46

44274 27

44365 9

51126 10

D2581RevA1 Manufactured No 100 Each 74.0000 2.0000



Mounting Bracket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 13

46086 2

48428 1

51120 10

Main Warehouse

WA 61

50872 12

51745 49

PD 09.11.02

PD 09.11.02

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Picklist Print

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Work Order ID: 52892

Parent Item: D3172-041RevC

Parent Item Name: Basket Base Assembly


Comments:

Start Date: 10/19/09

Required Date: 10/27/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3166-IRevA1		Manufactured	No			100	Each	18.0000	4.0000			
												
Basket Hoop												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA

18

51248

7

51951

11

D3174-IRevA1 Manufactured No

100

Each

20.0000

8.0000



Mounting Lug

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

20

41632

20

4 PD 09.10.26

PD 09.11.02

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Work Order ID: 52892

Parent Item: D3172-041RevC

Parent Item Name: Basket Base Assembly


Comments:

Start Date: 10/19/09

Required Date: 10/27/09


Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304EX0.75-16F		Purchased	No			100	sf	201.0648	48.0000			
												
Expanded Metal Flat SS												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	201.0648065	
110134	6.7	
111630	9.15	
111956	0.000017	
112147	8.29428947	
112311	28.9205	
112707	148	

PD 09.11.02

M304TS0.750W.065		Purchased	No			100	f	561.0601	53.6842			
												
304 SQ Tube .75x.75x.065W												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
WA	561.0601	
112398	561.0601	

PD 09.10.23

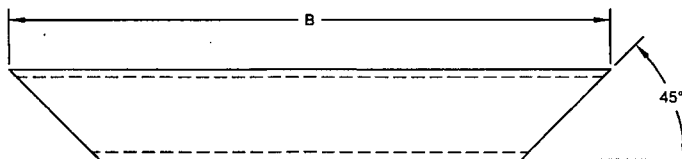
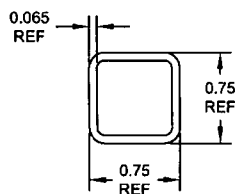
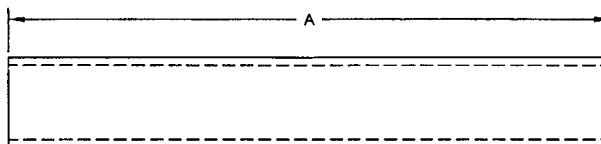
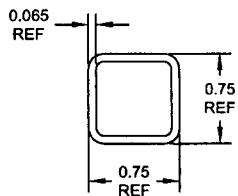
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PARTS LIST FOR D3172-041 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3172-1	2	—	96.00	RIB
D3172-3	2	—	25.50	RIB
D3172-5	6	33.09	—	RIB
D3172-7	3	26.81	—	RIB
D3172-9	1	94.50	N/A	RIB
D2012-117	4	N/A	N/A	CLEVIS
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRACKET
D2232-3	2	N/A	N/A	HINGE PLATE
D3166-1	4	N/A	N/A	RIB
D3174-1	8	N/A	N/A	MOUNTING LUG



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SUBJECT TO AMENDMENT
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WORK ORDER
NO. 52592
BC 09-10-12

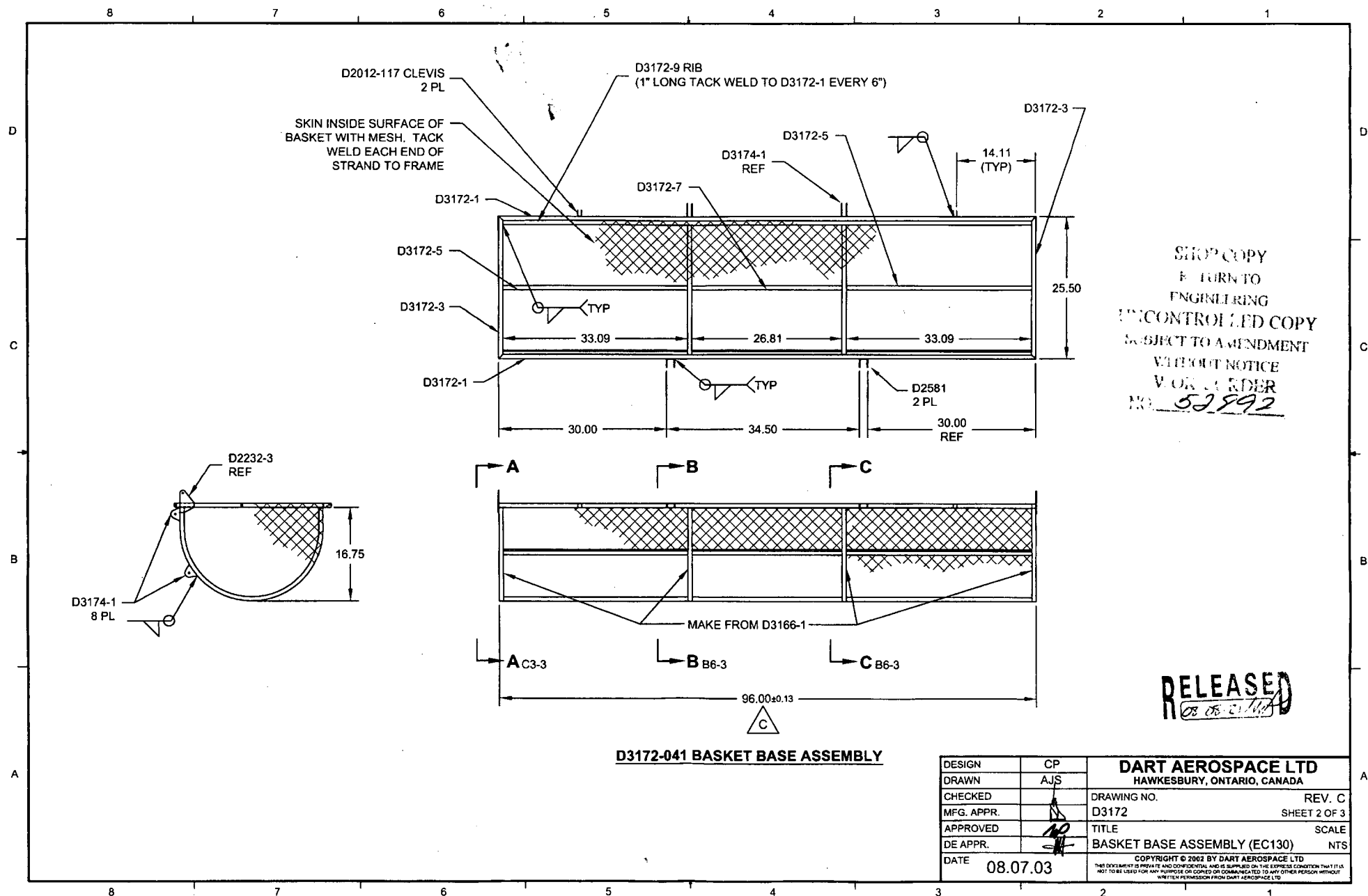
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08-05-21/10

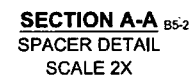


NOTES:

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004

C	FRAME MATERIAL WAS 0.060 WALL. MESH MATERIAL UPDATED. DRAWING MOVED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS.	AJS	08.07.03
B	ADD D3172-9 & D2012-117	CP	03.01.07
A	NEW ISSUE	DS	02.12.02
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3172	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET BASE ASSEMBLY (EC130)	NTS
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NO. 52792

RELEASE
05-08-21

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3172	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET BASE ASSEMBLY (EC130)	NTS
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